



Dart Aerospace Ltd.
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Canada

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D130-1048-101
Job Sheet 197900



Part No: D130-1048-101

Job Qty: 1 pcs

Part Name: H130/EC130 - FWD Crosstube - High



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/8/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: IIN-D130-1048 REV.B /IIN-D130-1048 REV.C IPP REV:A 18.08.27 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Handfinish - 4 - Assembly	1 pcs	8/8/19		0.00	0.25	Handfinish - 4 - 1		
							Handfinish - 4 - 10		
							Handfinish - 4 - 11		
							Handfinish - 4 - 12		AL 19-8-21
							Handfinish - 4 - 13		
							Handfinish - 4 - 14		
							Handfinish - 4 - 15		
							Handfinish - 4 - 2		
							Handfinish - 4 - 3		
							Handfinish - 4 - 4		
							Handfinish - 4 - 5		
							Handfinish - 4 - 6		
							Handfinish - 4 - 7		
							Handfinish - 4 - 8		
							Handfinish - 4 - 9		
120	QC 7	1 pcs	8/8/19		0.00	0.00	QC 7 - 10		
							QC 7 - 13		
							QC 7 - 14		
							QC 7 - 15		
							QC 7 - 17		
							QC 7 - 18		
							QC 7 - 19		
							QC 7 - 2		
							QC 7 - 28		
							QC 7 - 3		
							QC 7 - 30		
							QC 7 - 34		
							QC 7 - 36		
							QC 7 - 37		
							QC 7 - 41		
							QC 7 - 47		



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Container No: S207756



Part: D130-1048-101

Job No: 197900

Serial No/Batch: S207756

Revision: B/ C

Inspector:

Exp Date:

Instructions: TC STC SH19-4 Issue 1, 5A4, 570, SR04320NY dated 19/03/26

Plex 7/18/19 10:16 AM Dart.lajeunesse.marie

					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	DAS AUG 21 2019 8:38
					QC 7 - 50	9-89
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
130	Packaging 3-1 - Stock - B4B	1 pcs	8/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	DAS 78
					Packaging 3 - 25 - B4B	9-89
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	OCT 09 2019
					Packaging 3 - 36 - B4B	DAS 21
135	DC - 1 - B4B	1 pcs	8/8/19	0.00 0.00	DC - 1 - B4B	9-89
					DC - 2 - B4B	
140	QC 21 - FG	1 pcs	8/8/19	0.00 0.00	QC 21 - FG - 21	DAS 21
					QC 21 - FG - 70	9-89
					QC 21 - SA - 53	

Part Op 110 - ASSEMBLE AS PER DWG (HAND TIGHT)

Descriptions: 120 - QC7-Inspect Chemical Conversion Coat

130 - (Identify as per dwg & Stock Location: _____), Identify and pack for shipping as per PPP D130-1048-101
Location: _____

135 - Photocopy blue file and create labels as per PPP D130-1048-101 chg 001
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN6C42A	Bolt	2 Ea (2 ea)	110-Handfinish - 4 - Assembly	
D130-1048-141	EC130 Fwd Crosstube	1 pcs (1 ea)	110-Handfinish - 4 - Assembly	
D5595-1	Fwd Stop Block	2 pcs (2 ea)	110-Handfinish - 4 - Assembly	
D5595-3	Fwd Stop Block Washer	2 pcs (2 ea)	110-Handfinish - 4 - Assembly	
MS21043-6	Nut	2 Ea (2 ea)	110-Handfinish - 4 - Assembly	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Handfinish - 4 - Assembly	AN6C42A	5125521 (2)	15	0
	D130-1048-141	5200729 (1)	0	0
	D5595-1	5108299 (2)	2	0
	D5595-3	5103360 (2)	2	0
	MS21043-6	5203269 (2)	99	0

Part Specifications

Specifications could not be found.

Plex 7/18/19 10:16 AM Dart.lajeunesse.marie

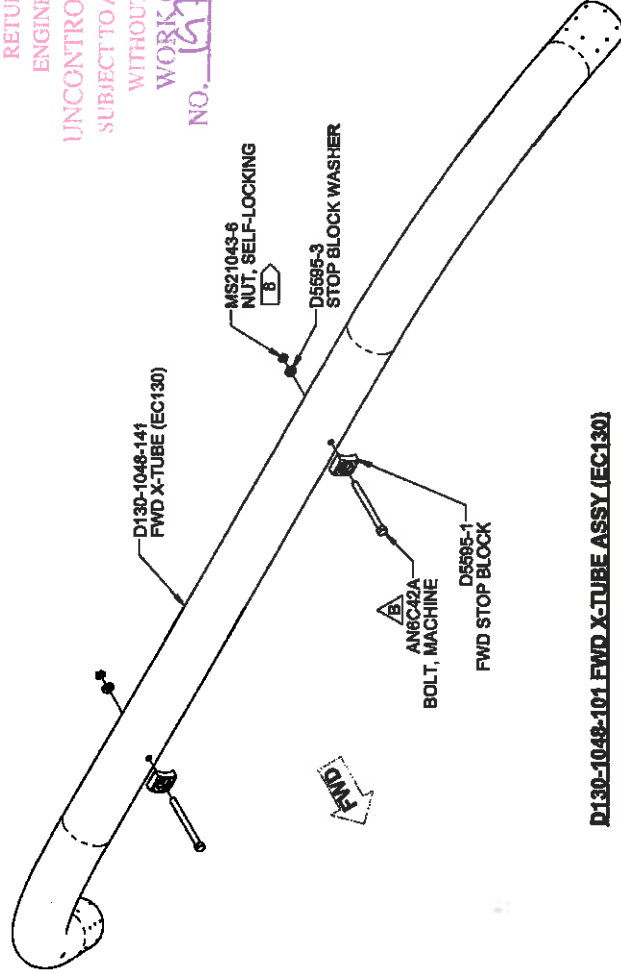
5x333

8 7 6 5 4 3 2 1

QTY -101	P/N	DESCRIPTION
X	D130-1048-101	FWD X-TUBE ASSY (EC130)
1	D130-1048-141	FWD X-TUBE (EC130)
2	D5685-1	FWD STOP BLOCK
2	D5685-3	STOP BLOCK WASHER
2	AN6C42A	BOLT, MACHINE
2	MS21043-6	NUT, SELF-LOCKING

△/B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16700 NLS
19-0718



D130-1048-101 FWD X-TUBE ASSY (EC130)

RELEASE
2019 JUN 19 W/D
ECN 19-025

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: N/A
 - 4) UNITS: N/A
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 18.3 LBS
 - 8) INSTALL FASTENERS HAND TIGHT ONLY

B	REWORK: AN6C42A WAS AN6C44A. REMOVED NOTE TO WET INSTALL WITH PENETRANT A-13. WEIGHT 18.3 LBS WAS 17.34 LBS. REMOVED ITEM NUMBERS AND BALLOONS	ZF	18.12.19
A	NEW ISSUE	ZF	18.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	NO	NO
DRAWN	ZF	ZF	ZF
CHECKED	MW	MW	MW
MFG. APPR.	JFS	JFS	JFS
APPROVED	NO	NO	NO
DE APPR.	CP	CP	CP
DATE	18.12.19	18.12.19	18.12.19
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D130-1048-101			
REV. B			
SHEET 1 OF 1			
TITLE FWD X-TUBE ASSY (EC130)			
SCALE NTS			
CONFIDENTIAL & NOT TO BE RELEASED OUTSIDE THE COMPANY WITHOUT AUTHORIZATION			

APPROVED



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: